

Date: Monday, 2/11/2008 2:12:42 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 37353	
Estimate Number : 12713	
P.O. Number :	Part Number : D353641
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31997	Material :
Written By :	Due Date : 2/18/2008 Qty: 12 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



Comment: Qty.: 0.7144 sf(s)/Unit Total : 8.5730 sf(s)
NEOPRENE SHEET 0.063
Batch: 106614 LB 8-2-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3536
Dwg Rev: A
Prog Rev: A

LB 8-2-12



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 8-2-12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 08/02/13 (X12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: FP.

JS 08/02/13 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:43 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 37353

Part Number: D353641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/14

Job Completion



mini 2008/2/13

(12)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37353
Description: Gasket		Part Number:	D3536-41
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.98	+/-0.030	27.98	*			
25.08	+/-0.030	25.08	*			
18.50	+/-0.030	18.50	*			
15.00	+/-0.030	15.00	*			
12.47	+/-0.030	12.47	*			
8.97	+/-0.030	8.97	*			
6.93	+/-0.030	6.93	*			
3.43	+/-0.030	3.43	*			
2.00	+/-0.030	2.00	*			
4.00	+/-0.030	4.00	*			
Ø0.19	+0.005/-0.001	.19	*			
3.90	+/-0.030	3.90	*			
1.88	+/-0.030	1.88	*			
0.30	+/-0.030	.303	*			
0.30	+/-0.030	.303	*			
0.063	+/-0.010	.063	*			

Measured by:	HB
Date:	8-2-12

Audited by:	f
Date:	08/02/13

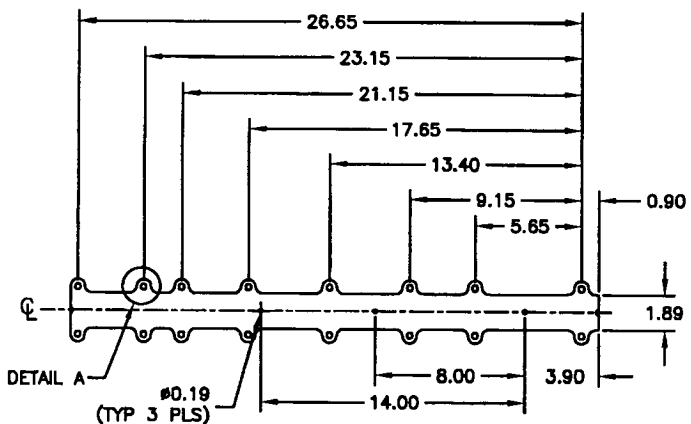
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EF

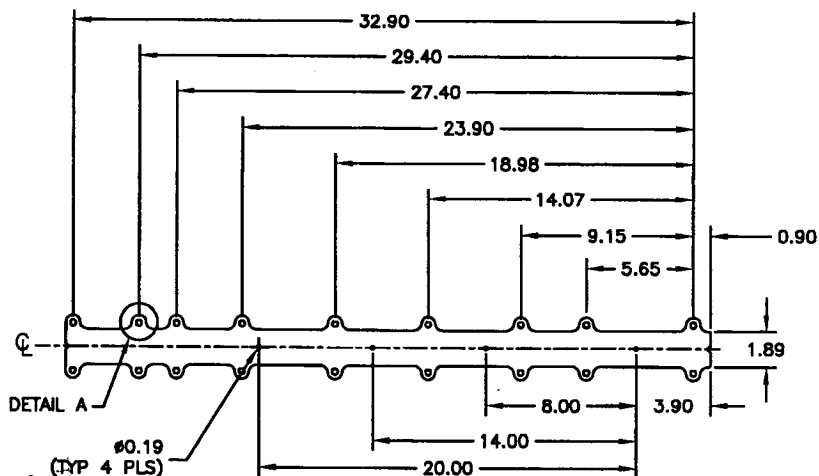
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

RELEASED
09.02.12



D3536-11 GASKET



D3536-13 GASKET

NOTES

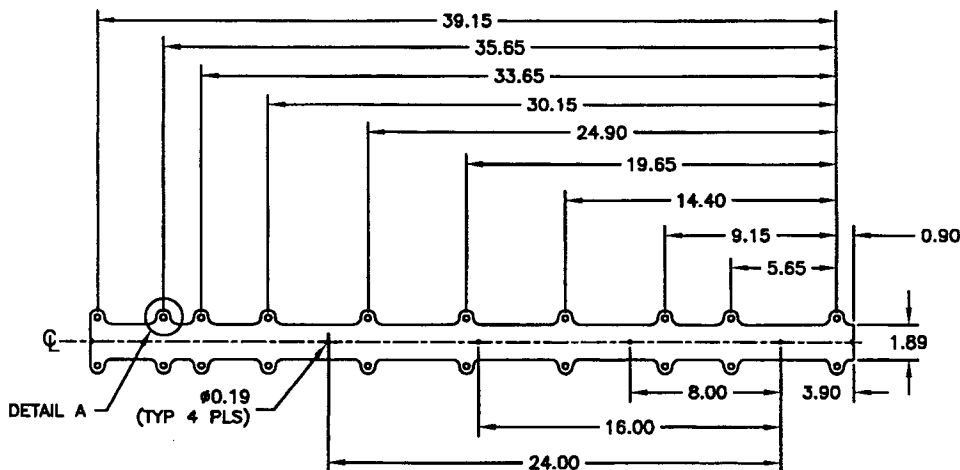
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER
NO. 37353

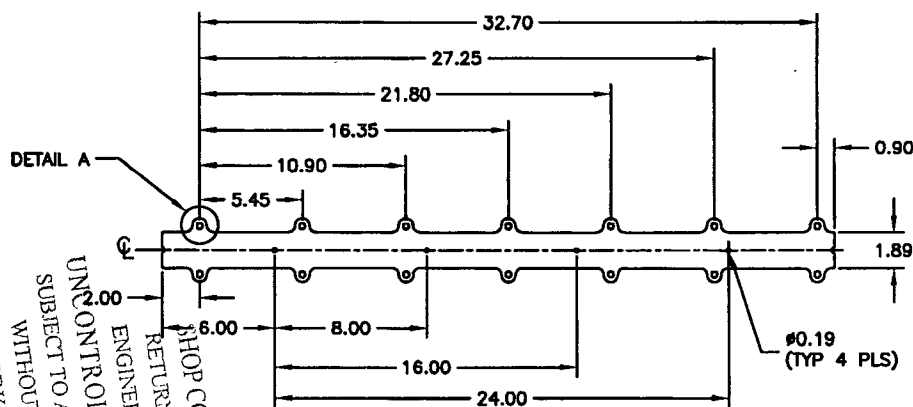
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	DRAWING NO. D3536
				SHEET 2 OF 6
		SCALE	1:10	REV. A

RELEASED
070212



D3536-15 GASKET



D3536-21 GASKET

NOTES

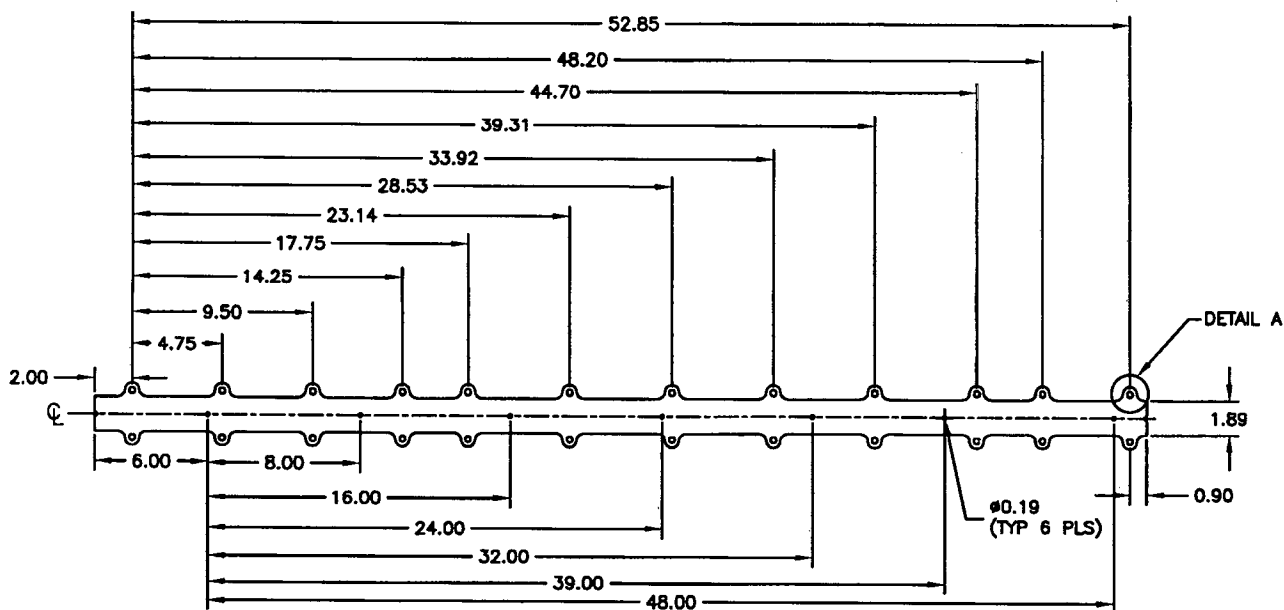
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- 3) PART IS SYMMETRICAL ABOUT C
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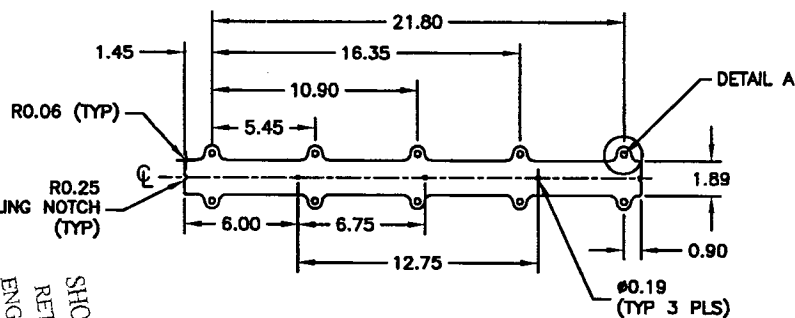
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CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 3 OF 6
		SCALE 1:10

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07.02.12



D3536-23 GASKET



D3536-25 GASKET

NOTES

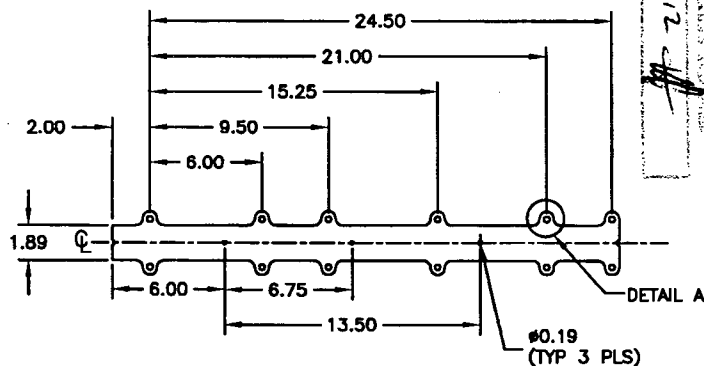
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- 3) PART IS SYMMETRICAL ABOUT ϕ
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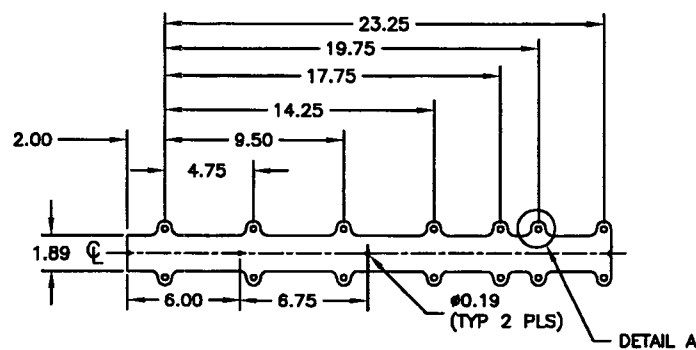
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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 4 OF 6	SCALE 1:10

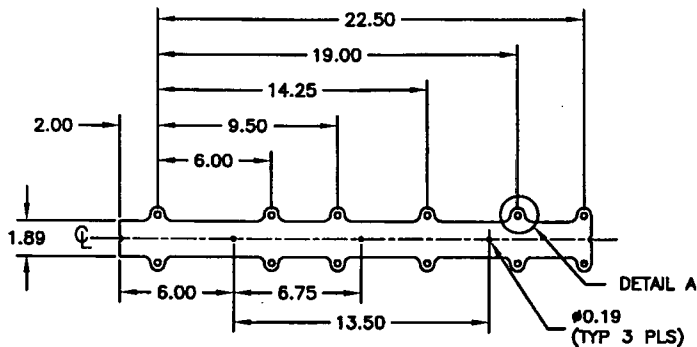
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

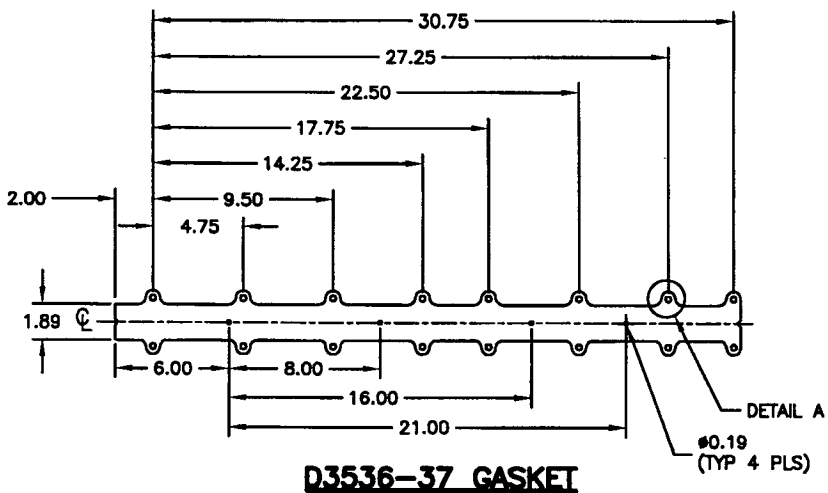
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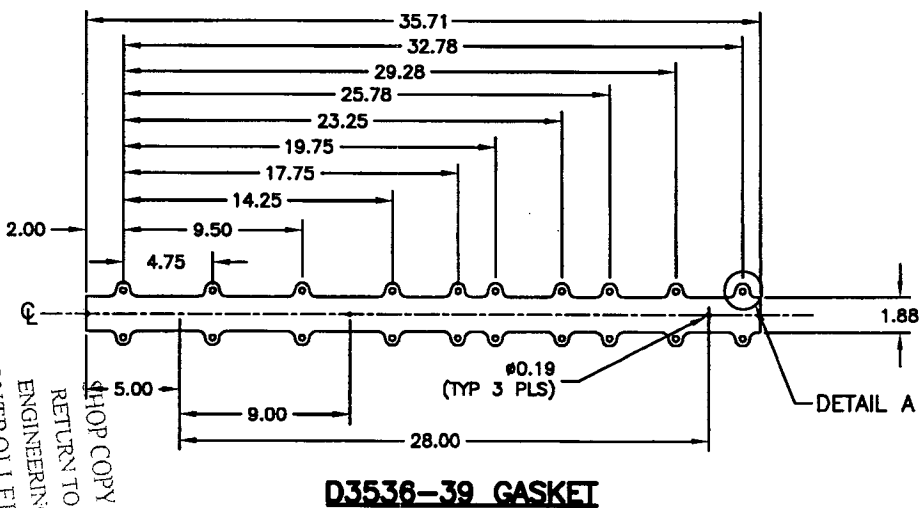


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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 5 OF 6
				SCALE 1:10

07.02.02
PH



D3536-37 GASKET



D3536-39 GASKET

NOTES

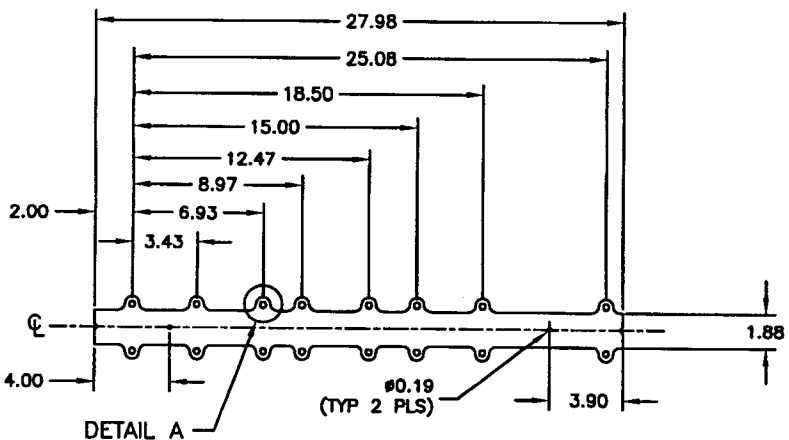
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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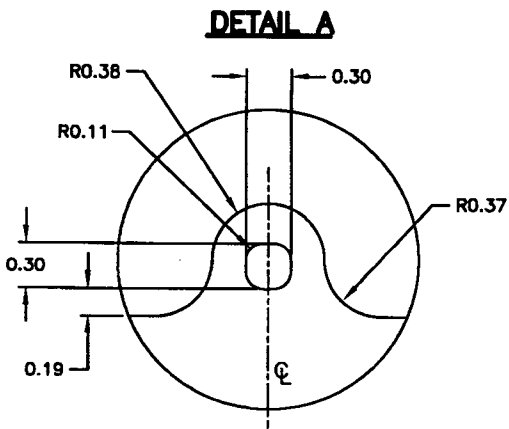
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07/01/02

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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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